



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2499**Job Sheet 197568****Part No:** D2499**Job Qty:** 6 pcs**Part Name:** Mounting Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/10/19**Job Tracking No:****Due Date:** 8/16/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV C IPP A 00.06.26 Removed P/O for powder coat EC IPP C Rev C dwg 07-09-25 DD verified by EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	8/16/19	8/16/19	0.00	0.40	Bandsaw - 1		mmL 19/08/02
110	HAAS 4 Axis - B4B	6 pcs	8/16/19	8/16/19	1.00	3.00	HAAS - 1 - B4B		mmL 19/08/02
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs	8/16/19	8/16/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		mmL 19/08/02
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

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**Container No:** S202450**Part:** D2499**Job No:** 197568**Serial No/Batch:** S202450**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/02/19

130	QC 8	6 pcs	8/16/19	0.00 0.00	QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	A 19-08-02
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
140	Handfinish - 1-1 Chemical-B4B	6 pcs	8/16/19	0.00 0.96	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	A AUG 06 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	

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					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 Powdercoat - 2 White GI(S)- B4B	6 pcs	8/16/19	0.00 0.80		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	BEB 18-08
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160 QC 3	6 pcs	8/16/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	Aug 16 2019
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	6 pcs	8/16/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC STS27
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	6 pcs	8/16/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
					AUG 19 2019 70 9-89
Part Op 100 - (Bandsaw)Cut blanks: 8.500" x 4.000" Descriptions: 110 - (HAAS CNC vertical machine #1)Machine as per folio D2499 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) *****mask slot as per dwg***** 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
START: 3:40 TEMP: 375° FINISH: 3:55 S 193459					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	2.4000 ft (.4 ea)	100-Bandsaw - 1	5150595-2.14	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B1.000X04.000	2	47	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order:	197568
Description: Mount		Part Number:	D2499
Inspection Dwg: D2499 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.585	+/-0.010	.585	/		vern	mm -08
1.252	+/-0.010	1.252	/		Height	3006
2.085	+/-0.010	2.085	/		vern	mm -08
3.585	+/-0.010	3.585	/			
3.960	+/-0.010	3.960	/			
0.375	+/-0.010	.375	/			
0.875	+/-0.010	.878	/		Depth G	
1.500	+/-0.010	1.502	/		vern	mm -08
3.525	+/-0.010	3.525	/		Height G	3006
4.150	+/-0.010	4.148	/			
5.200	+/-0.010	5.200	/			
3.460	+/-0.010	3.459	/			
3.335	+/-0.010	3.335	/			
2.541	+/-0.010	2.541	/			
0.25	+/-0.010	.248	/		vern	mm -08
5.700	+/-0.010	5.699	/			
0.115	+/-0.010	0.111	/			
0.770	+/-0.010	0.766	/			
1.000	+/-0.010	0.990	/		microm	mm -01
0.25	+/-0.010	.250	/		microm	mm -01
0.38	+/-0.010	.375	/		Depth G	
0.250	+/-0.010	.244	/		vern	mm -01
0.500	+/-0.010	.502	/			
R0.25	+/-0.010	.25	/		AG	
R0.50	+/-0.010	.500	/			
R0.38	+/-0.010	.38	/			
R0.13	+/-0.010	.13	/			
R0.25	+/-0.010	.25	/			
R0.06	+/-0.010	.06	/			
Ø0.257	+0.006/-0.001	.257	/		vern	mm -08
Ø0.386	+0.006/-0.001	.392	/			

Measured by: mm -08		Audited by: B		Prototype Approval:		N/A	
Date: 19/08/01		Date: 19-08-02		Date:		N/A	
Rev	Date	Change	Revised by		Approved		
A	08.04.11	New Issue	KJ/DD				

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					